

17/09

Date: Tuesday, 9/11/2007 10:58:16 AM
 User: Chantal Lavoie

Process Sheet

Customer : N/A	Drawing Name : SHIM
Job Number : 34549	
Estimate Number : 13011	
P.O. Number : N/A	Part Number : D36441
This Issue : 9/11/2007	Drawing Number : D3644 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : U/R
Previous Run : N/A	Material : N/A
Written By : _____	Due Date : 9/18/2007
Checked & Approved By : _____	Qty: 10 Um: Each
Comment : Est Rev:A New Issue 07-07-20 JLM	Verified By:EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S050	2024-T3 .050 sheet
-----	-------------	--------------------



Comment: Qty.: 0.1747 sf(s)/Unit Total : 1.7472 sf(s)

2024-T3 .050 sheet

Batch: M105646 IB 07-09-19

2.0	WATER JET.	FLOW WATER JET
-----	------------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3644

Dwg Rev: A

Prog Rev: A

IB 07-09-19

(10)

2-Deburr if necessary

SAD

07/09/20

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 07-09-19

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

E 02/09/21 (10)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR

07-10-02

(10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/10/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/11/2007 10:58:17 AM
User: Chantal Lavoie

Process Sheet

Customer:

Drawing Name: SHIM

Job Number: 34549

Part Number: D36441

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/10/2

SP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock
Location: _____

ENGINEERING
APPROVAL

LE 07.10.15

7/10/2

SO

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

18

7/10/22

Job Completion



LE 07.10.16

POSITIVE RECALL

EFFECTIVE 07.09.11 AUTH LE

RELEASED LE DATE 07.10.15

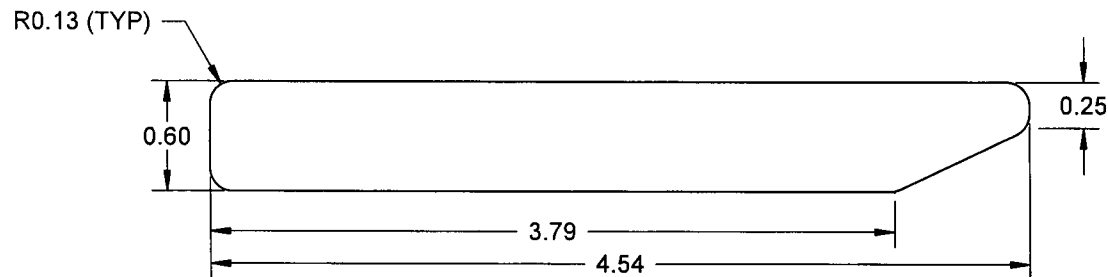
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3644-1 SHIM
(REPLACES GENEVA P/N G10610-3)

blsve
W/D

PRELIMINARY ISSUE

07-09-07 *LE*

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3644-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.01lbs

A	NEW ISSUE; REPLACES G10610-3		LE	07.07.27
REV.	DESCRIPTION		BY	DATE
DESIGN	DTI	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
DRAWN	<i>CE</i>			
CHECKED	<i>EB</i>	DRAWING NO.	REV. A	
MFG. APPR.	<i>W/D</i>	D3644	SHEET 1 OF 1	
APPROVED		TITLE	SCALE	
DE APPR.		SHIM	1:1	
DATE	07.07.27		COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

